

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009707**Date Inspected:** 01-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 245**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Deck Panel**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Christopher D'souza was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

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This QA Inspector observed ZPMC welding personnel performing automated, in gantry, Gas Metal Arc Welding (GMAW) of closed rib Partial Joint Penetration (PJP) welds to deck plate designated as DP3052-001 and DP3064-001 on Gantry #2. In process GMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

This QA Inspector observed ZPMC welding personnel performing automated, in gantry, Submerged Arc Welding (SAW) of closed rib Partial Joint Penetration (PJP) welds to deck plate designated as DP3052-001 and DP3064-001 on Gantry #2. In process SAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

Welders are identified as 059418, 059403, 059416, 201840, 201788 and 059421. ZPMC QC is identified as Chen Shi gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2342 – U1

This QA Inspector observed ZPMC welding personnel's performing Flux cored arc welding (FCAW) on

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Diaphragms to U-Rib designated as DP 3065-001-285~288. Welder is identified as 059433. ZPMC QC is identified as Chen Shi gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133

Bay 12

This QA Inspector observed ZPMC welding personnel's performing repairs by Flux cored arc welding (FCAW) on Deck panel designated as DP 403-001. Welder is identified as 059371. ZPMC QC is identified as Zhang Jingxin. The welding variables recorded by QC appeared to comply with the WPS – 345-FCAW-2G(2F) Repair 1

Repairs were being performed on areas marked as visual rejects on DP 403-001 U-rib to deck plate weld. These areas were marked for repairs by ZPMC QC.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Dsouza,Christopher	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
